

Date: Monday, 08/09/2008 8:06:26 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	CABLE GUARD
<b>Job Number</b> :	41875	<b>Part Number</b> :	D34993
<b>Estimate Number</b> :	12410	<b>Drawing Number</b> :	D3499 REV B
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A
<b>This Issue</b> :	08/09/2008	<b>Drawing Revision</b> :	B
<b>Prsht Rev.</b> :	NC	<b>Material</b> :	
<b>First Issue</b> :	/ /	<b>Due Date</b> :	15/09/2008
<b>Previous Run</b> :	28503	<b>Qty:</b>	6
<b>Written By</b> :		<b>Um:</b>	Each
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est Rev:A New Issue 06-05-05 JLM Est Rev:B As per Rev B 06-08-31 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MUHMWB625	UHMW .625 Black Tivar 1000
-----	-----------	----------------------------



**Comment:** Qty.: 1.1351 sf(s)/Unit Total : 6.8103 sf(s)  
UHMW .625 Black Tivar 1000  
Batch: 109313 AB 8-9-18

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
1-Cut as per Dwg D3499  
Dwg Rev: B AB 8-9-18  
Prog Rev: B  
  
2-Deburr if necessary 11



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

AB 8-9-18

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



**Comment:**  
HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA636 Rev: B & Dwg D3499 Rev: B





2-Deburr per dwg D3499



M.A 08/09/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3499-3 PAR # NA Fault Category: Prod / Engr. CO. NCR: Yes No DQA: DD Date: 08/10/09  
D3499-012 / D412-742-018 Resolution: \_\_\_\_\_ Disposition: machined parts. QA: N/C Closed: DD Date: 08/10/09

NCR: <u>41875</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/27	4.0	All the Y-values in the program were wrong for prog #1000 <del>The mat is not thick enough at some places</del>	 08/10/09	Scrap and Destroy no replace. Qty (X) - extra was cut on water jet.	J.A. 08/09/27	S 08/09/29	 08/10/09	S 08/09/27
		<del>The gage was not</del> The Dim of 0.630 was machined at 0.493"		Fix program to prevent scrapping gram				
08/10/03	6.0	First counter bore was start on the wherry side about .083" deep P.C. operator error	 08/10/03	Scrap no replace Qty (X)	S.F. 08/10/03	S 08/10/03	 08/10/03	S 08/10/03

NOTE: Date & initial all entries

Date: Monday, 08/09/2008 8:06:26 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABLE GUARD

Job Number: 41875

Part Number: D34993

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

L.A 08/09/27

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE  
C'BORE AS PER DWG D3499

8/08/03 (7)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

← (PTD)  
8/08/07

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8/08/03 (7)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: ST207

ND 08/10/06 (A)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/08 H

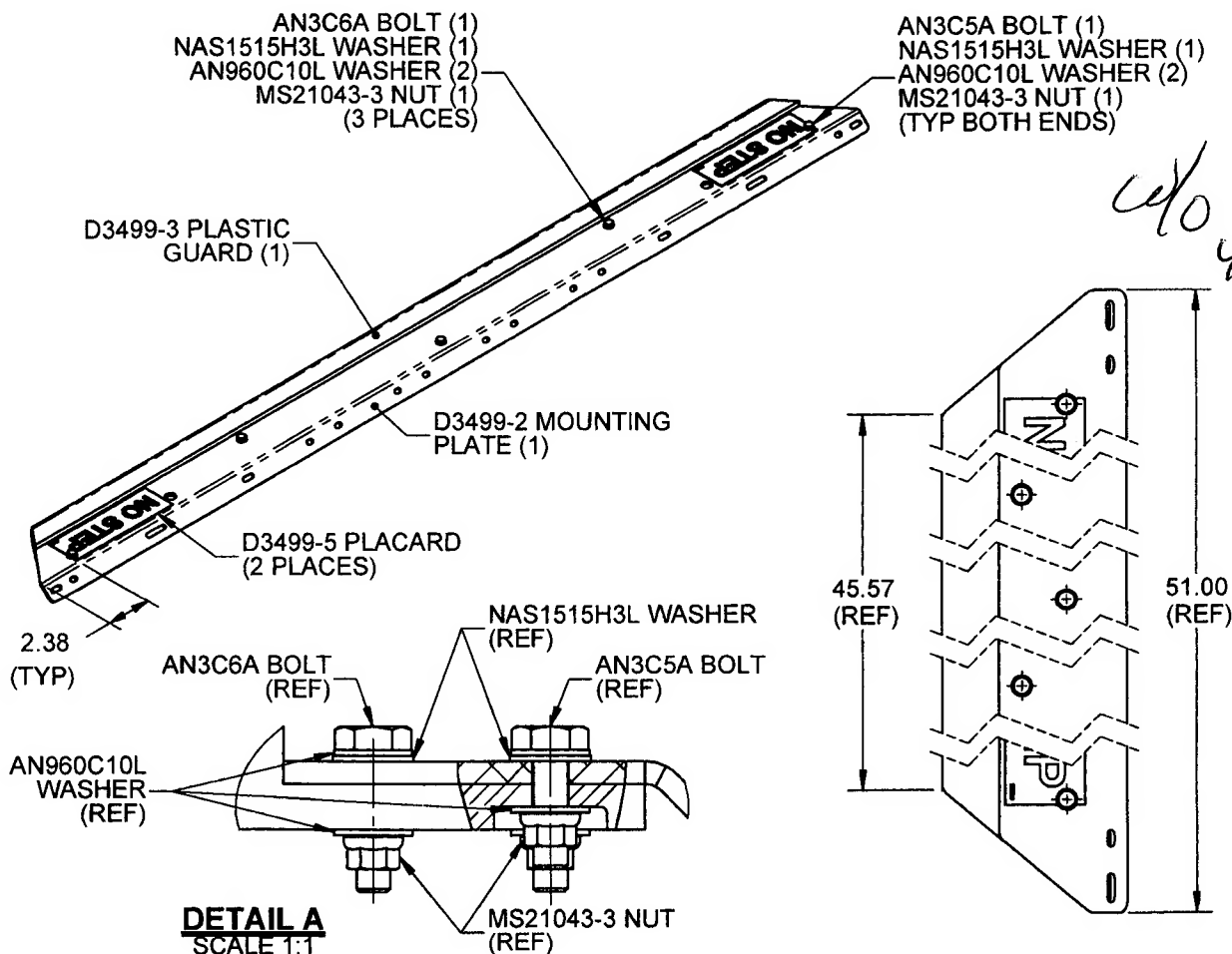
Job Completion



u 08/10/08

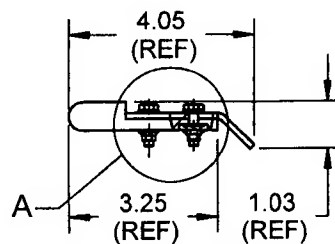


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3499	REV. B SHEET 1 OF 4
DATE 06.08.15		TITLE CABLE GUARD	SCALE 1:4
A	06.04.11	NEW ISSUE	
B	06.08.15	RE-DESIGN D3499-2F/-3	



### D3499-042 CABLE GUARD ASSEMBLY

QTY -042	P/N	DESCRIPTION
X	D3499-042	CABLE GUARD ASSEMBLY
1	D3499-2	MOUNTING PLATE
1	D3499-3	PLASTIC GUARD
2	D3499-5	PLACARD
2	AN3C5A	BOLT
3	AN3C6A	BOLT
10	AN960C10L	WASHER
5	MS21043-3	NUT
5	NAS1515H3L	WASHER

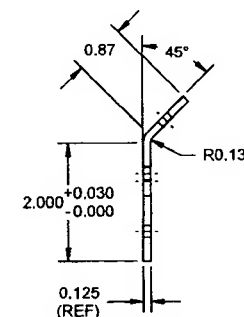
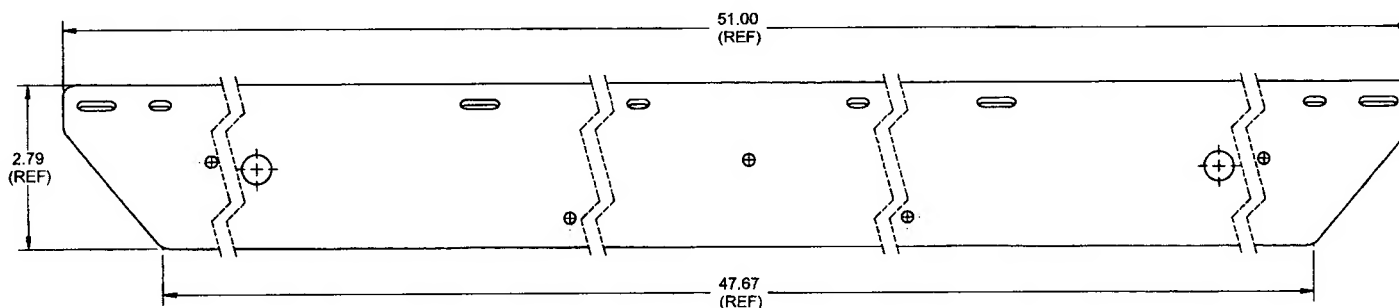
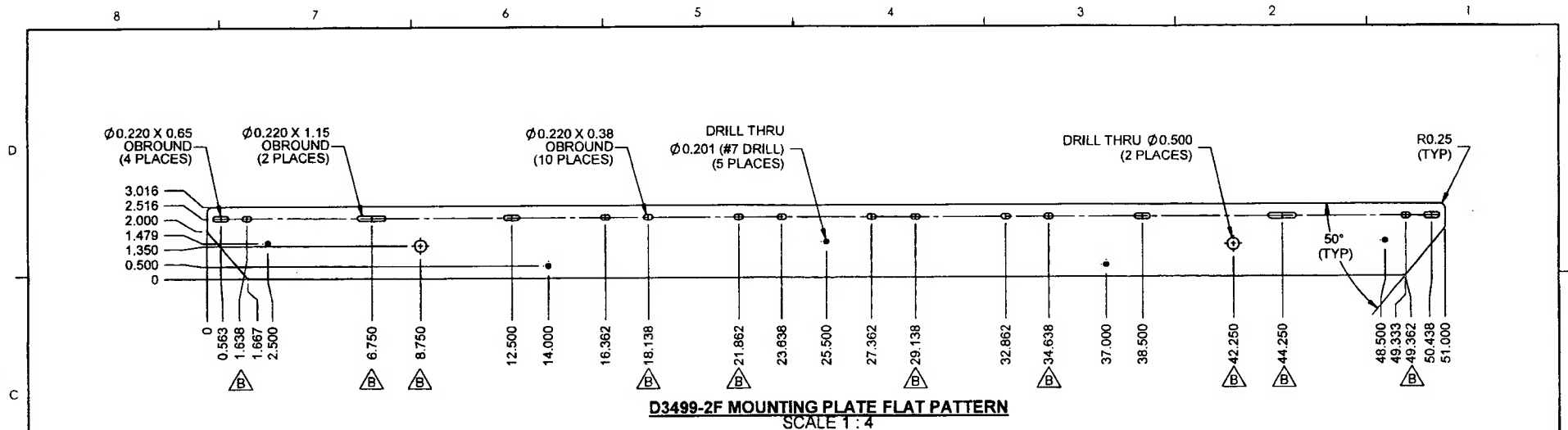


### NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



# **NOTES:**

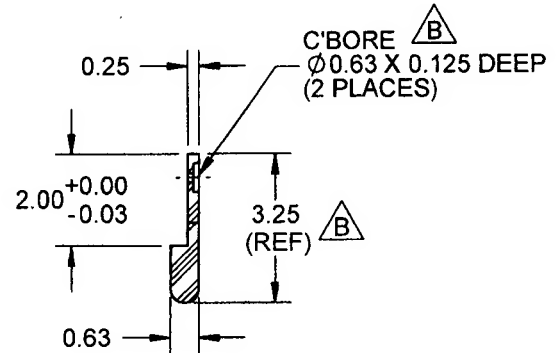
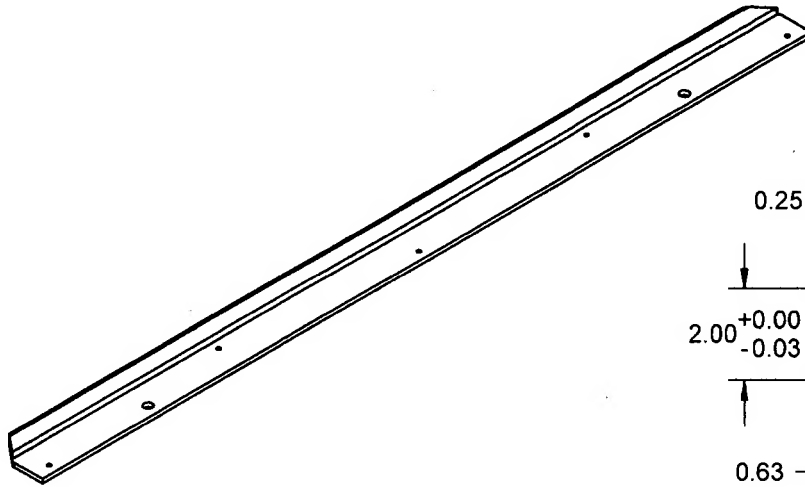
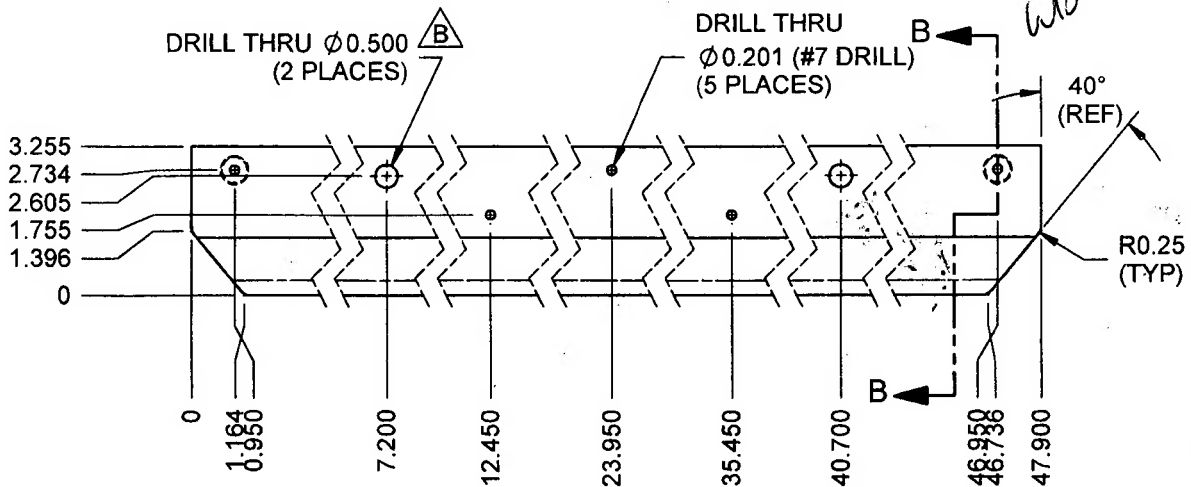
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (0.125 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005. 4.1  
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

41875

DESIGN <i>B</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3499</b>	REV. B SHEET 2 OF 4
DATE <b>06.08.15</b>		TITLE <b>CABLE GUARD</b> SCALE 1:2	
COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

**DART**

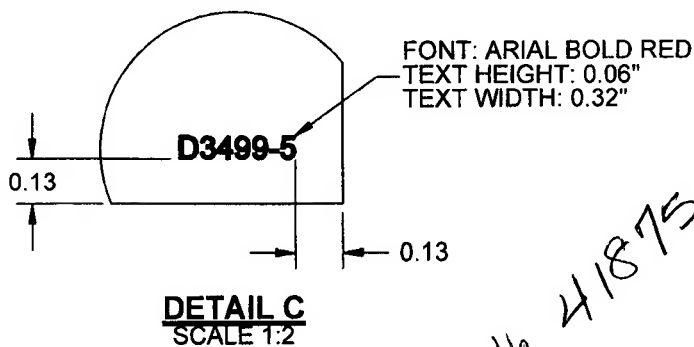
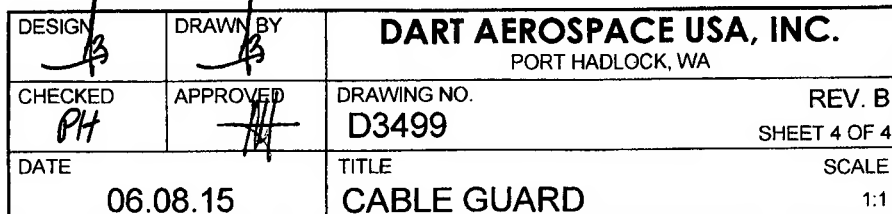
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3499</b>	REV. B SHEET 3 OF 4
DATE <b>06.08.15</b>		TITLE <b>CABLE GUARD</b>	SCALE 1:4

**SECTION B-B****D3499-3 CABLE GUARD****NOTES:**

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL (MUHMWB)
- 2) PART IS SYMMETRICAL AT CENTER LINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

<b>DART AÉROSPACE LTD</b>		<b>Work Order:</b> 41875
<b>Description:</b> CABLE GUARD		<b>Part Number:</b> D3499-3
<b>Inspection Dwg:</b> D3499-3, Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .261	+ .005 - .001	.262	*			
Ø .500	+ .006 - .001	.500	*			
1.755	+/- .010	1.750	*			
2.605	+/- .010	2.600	*			
2.734	+/- .010	2.731	*			
3.255	+/- .010	3.260	*			
1.164	+/- .010	1.167	*			
.950	+/- .010	.950	*			
7.200	+/- .010	7.206	*			
12.450	+/- .010	12.450	*			
23.950	+/- .010	23.950	*			
35.450	+/- .010	35.450	*			
40.700	+/- .010	40.700	*			
46.736	+/- .010	46.736	*			
46.950	+/- .010	46.950	*			
47.900	+/- .010	47.900	*			
2.00	+0.000/- .030	1.985	✓			
0.25	+/- .030	0.249	✓			
0.63	+/- .030	.630				

<b>Measured by:</b> B / A	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b> [Signature]
<b>Date:</b> 8-4-18	<b>Date:</b> 08/10/03	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



51111

11

7

1

3

33

10

200

1